

A

167.64

Dart Aerospace Ltd.

Friday, 02/05/2008 2:55:32 PM  
User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET ASSEMBLY
<b>Job Number</b> :	39013		
<b>Estimate Number</b> :	10278		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3121141
<b>This Issue</b> :	02/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3121 REV E
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	37610	<b>Drawing Revision</b> :	E
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	JUD 08.5.02	<b>Due Date</b> :	20/05/2008
<b>Comment</b> :	Est Rev: Pick: A 04.02.18 New issue KJ/DS Est Rev: B ECN 1060 07-11-12 DD verified by: EC		
		<b>Qty:</b>	30
		<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M174B1000X02000	17-4 SS Bar
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**Comment:** Qty.: 0.5775 f(s)/Unit Total: 17.3250 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1.000x02.000)

Identify for D3121-111

Batch: 107956

H.A 08/05/12

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blanks: (1.000" x 2.000") 6.600" long

SA

H.A 08/05/12

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111

2-Deburr

3-Scribe batch number

SA / H.A 08/05/12

(P10) →

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SA / H.A 08/05/12

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-141 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: D Date: 08/05/22  
 QA: N/C Closed: D Date: 08/05/30

NCR: 39013		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/22	# 24 30	Scrap, used carbon steel. RE operator used wrong mat. Did not look prior to cutting	[Signature]	have operator verify before cutting Scrap and Destroy and Replace with correct mat. Qty (2)	SA 08/05/22	[Signature]	[Signature]	[Signature]
08/05/22	# 30	1 Scrap Tap broken in part RE tap was worn out. it happens.	[Signature]	Scrap and Destroy and Replace Qty (x1) B# M107956	SA 08/05/22	[Signature]	[Signature]	[Signature]
08/05/22	# 30	1 part chamber not machined RE part was removed Piston to being finished	[Signature]	machine chamber Qty (1) manually Scrap and Destroy no replace	SA 08/05/22	[Signature]	[Signature]	[Signature]

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 2:55:32 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 39013

Part Number: D3121141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

LB 06/05/22 (30)

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-21

Bolt 1338594-230

SA 08/05/22

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-241 Bearing Ass

1339099-13 parts

SA 08/05/22

8.0

SMALL FAB 1.

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble D3121-141 as per Dwg D3121.

SA 08/03/22

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.05.27 (30)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57233

08/05/27 (30)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27

Job Completion



mf 08-05-27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39013
<b>Description:</b> Bracket		<b>Part Number:</b> D3121-111
<b>Inspection Dwg:</b> D3121	<b>Rev:</b> E	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	0.392	/			
0.75	+/-0.030	0.751	/			
0.375	+/-0.010	0.375	/			
2.14	+/-0.030	2.14	/			
1.96	+/-0.030	1.960	/			
0.280	+/-0.010	0.286	/			
3.330	+/-0.010	3.328	/			
3.630	+/-0.010	3.636	/			
R0.25	+/-0.030	R.25	/			
R0.375	+/-0.010	R.375	/			
Ø0.201	+0.005/-0.000	0.203	/			
0.100	+/-0.010	0.100	/			
4.580	+/-0.010	4.586	/			
6.18	+/-0.030	6.178	/			
5.89	+/-0.030	5.891	/			
0.080	+/-0.010	0.075	/			
0.300	+/-0.010	0.297	/			
30°	+/-0.1°	30°	/			
R0.25	+/-0.030	R.25	/			
0.130	+/-0.010	0.130	/			
0.664	+/-0.010	0.664	/			
0.381	+/-0.010	0.381	/			
0.201	+/-0.010	0.201	/			
0.400	+/-0.010	0.399	/			
0.580	+/-0.010	0.580	/			
100°	+/-0.1°	100°	/			
0.032	+0.000/-0.010	0.030	/			

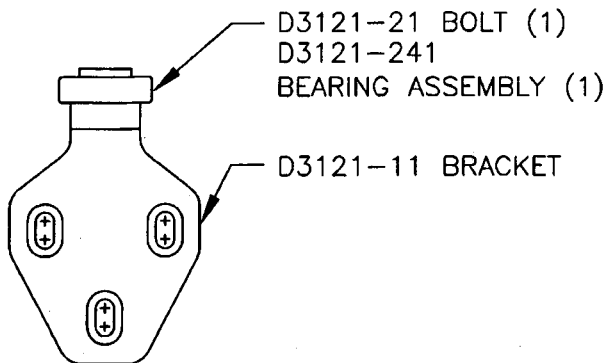
<b>Measured by:</b> SD/H.A	<b>Audited by:</b> DTP	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/05/13	<b>Date:</b> 08/05/14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	

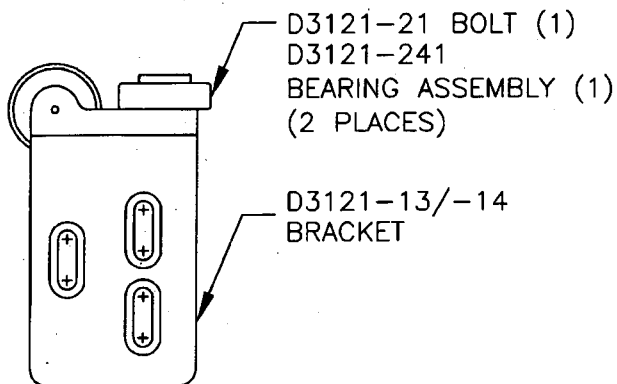


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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

RELEASED  
07.11.07

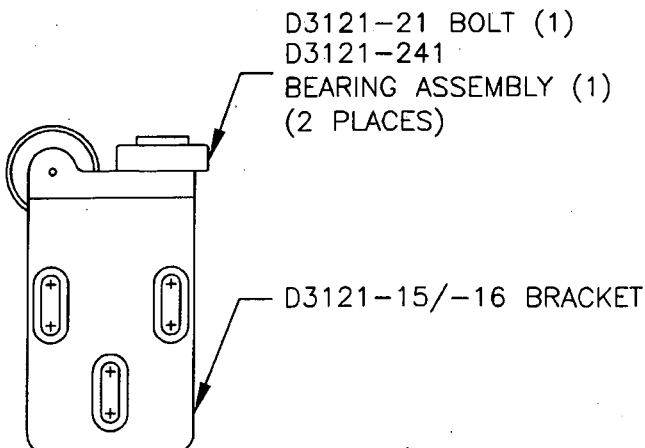


**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)

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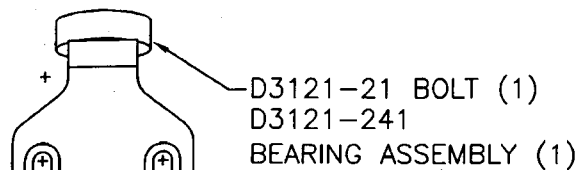
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(REPLACES PREMIER P/N B30-23000-35/-36)

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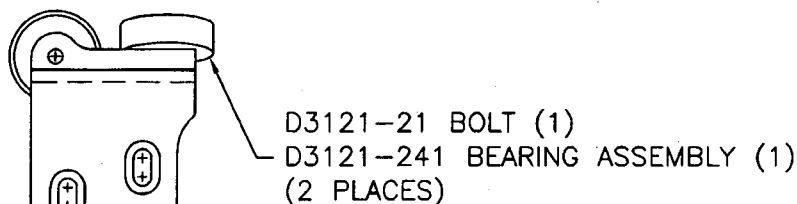
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-111 BRACKET

**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)

RELEASED  
07.11.07



D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)

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D3121-115/-116  
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-05/-06)

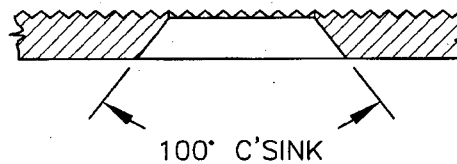
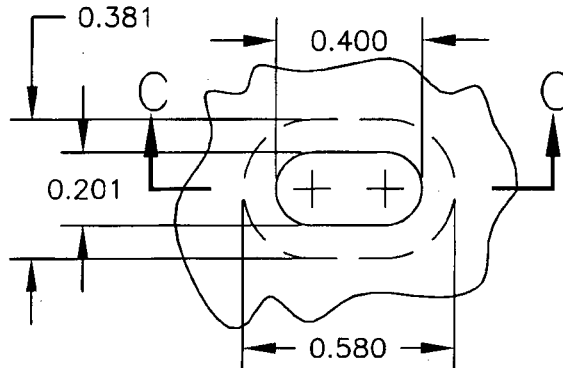
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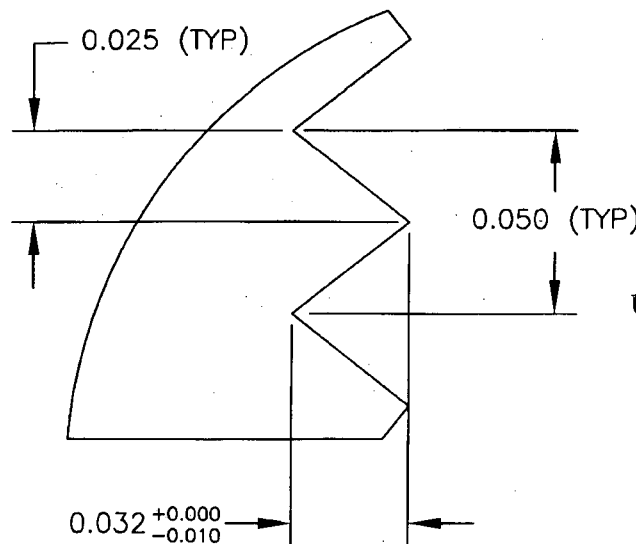
**DETAIL A:**  
**SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED



**SECTION**  
**C-C**

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**DETAIL B:**  
**RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20



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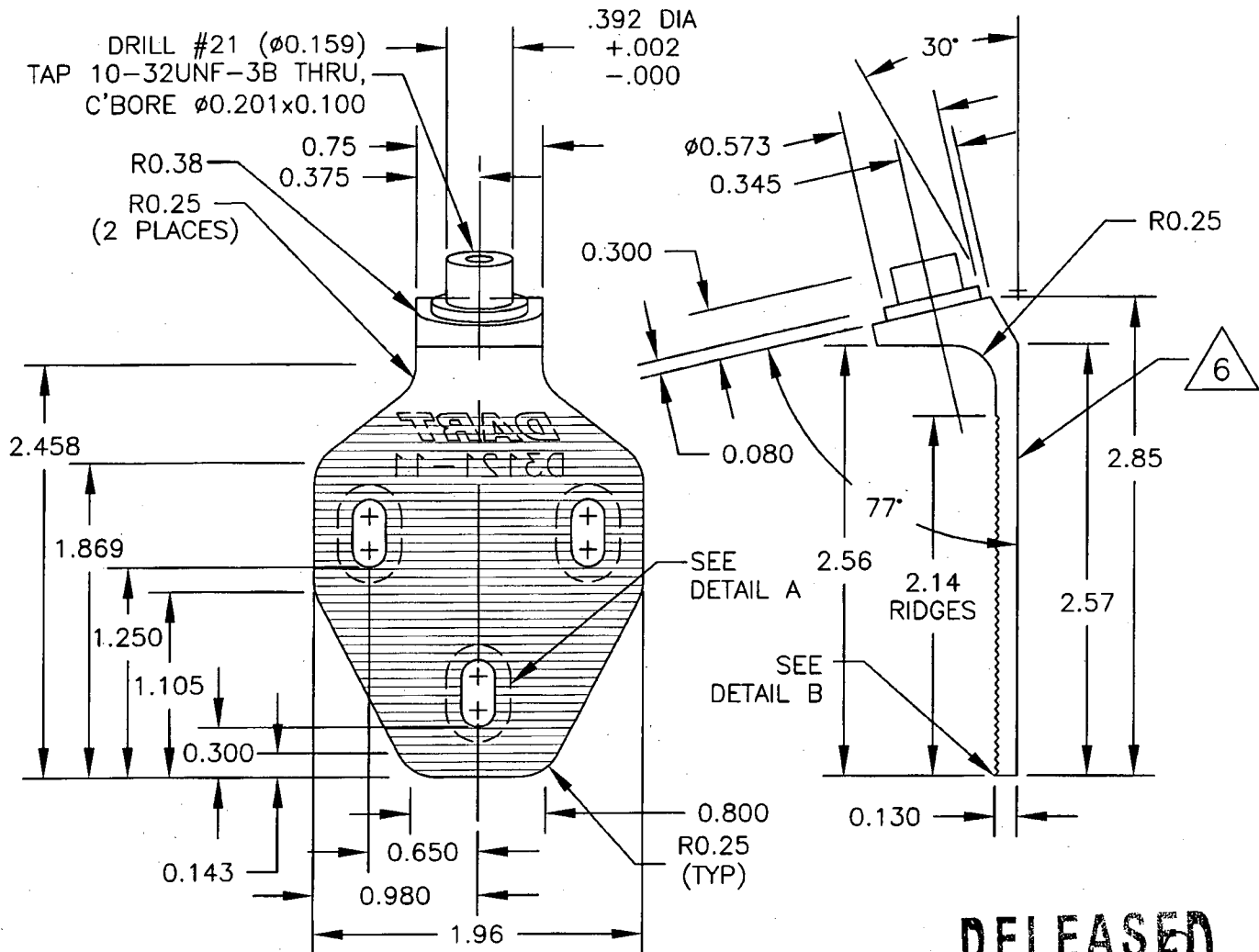
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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**RELEASED**  
07.11.07**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

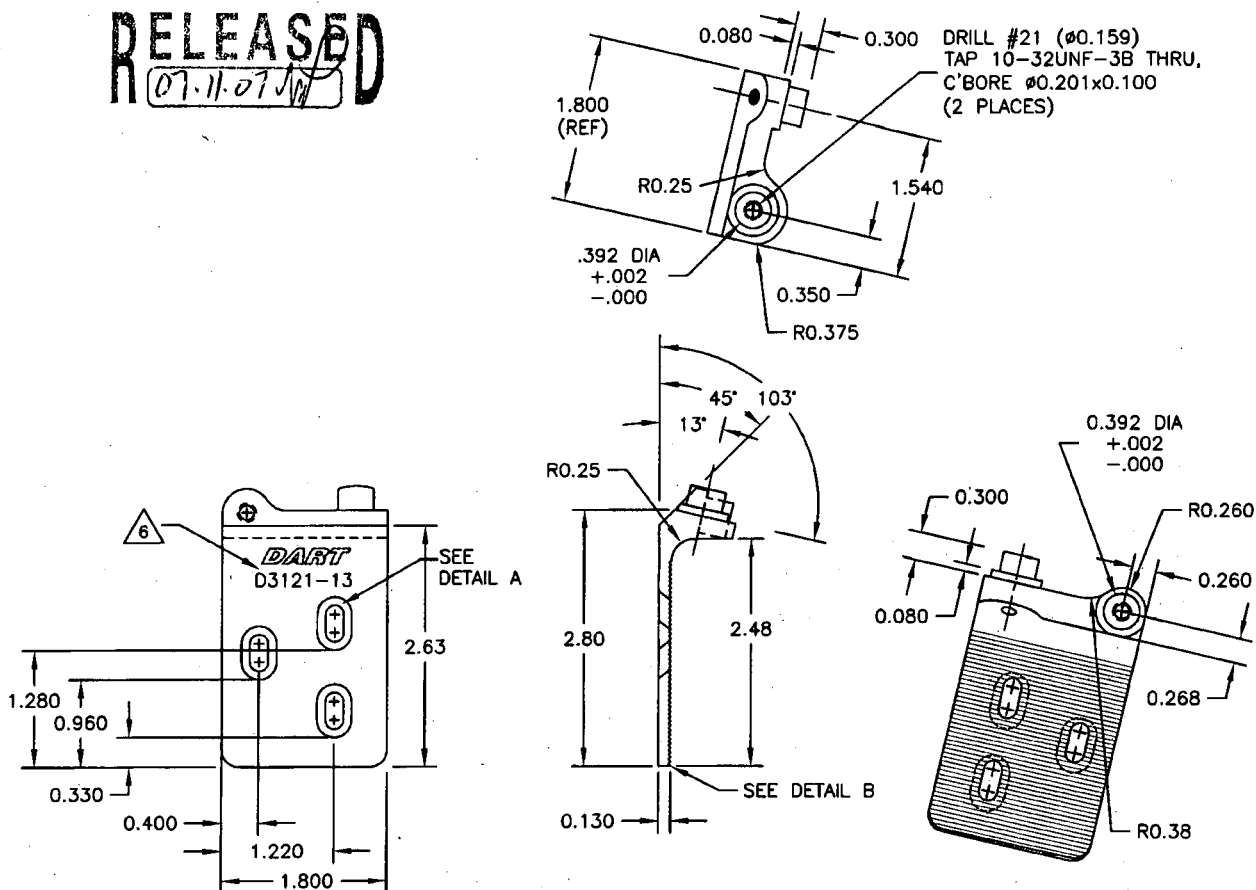
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07

**D3121-13 BRACKET (SHOWN)**  
**D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

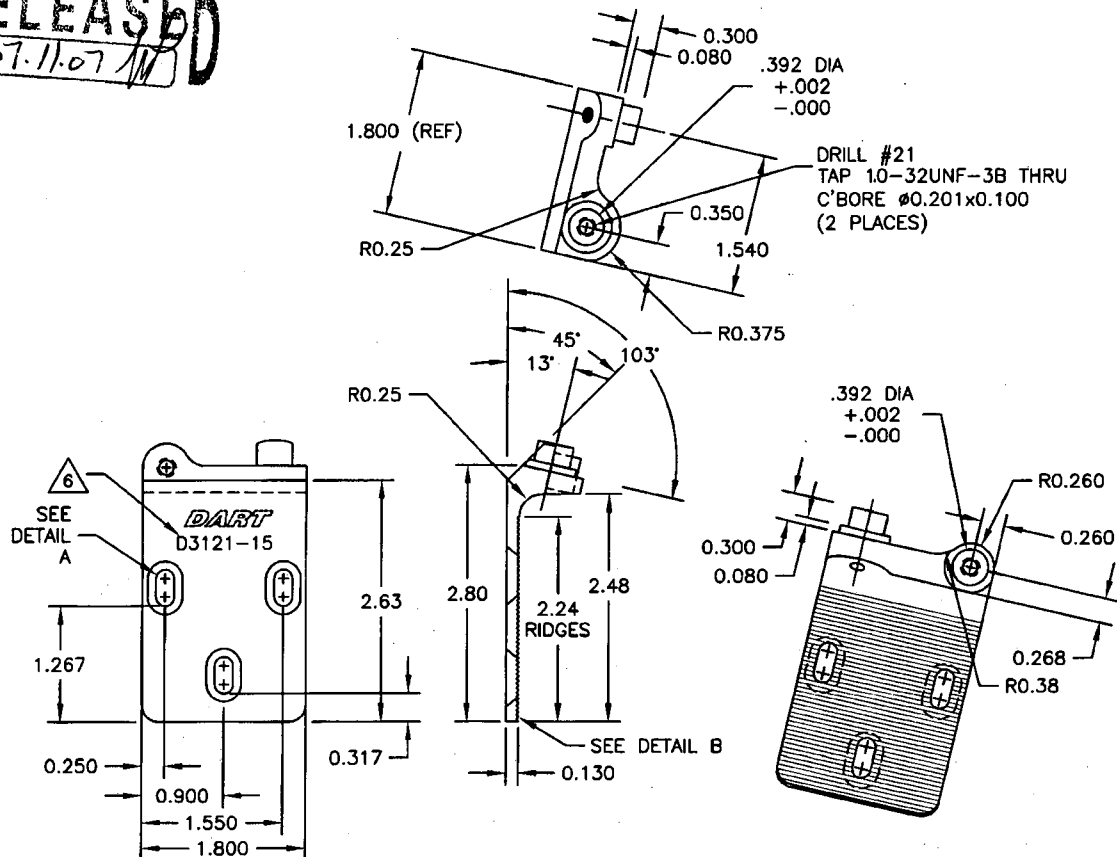
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07**D3121-15 BRACKET (SHOWN)****D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

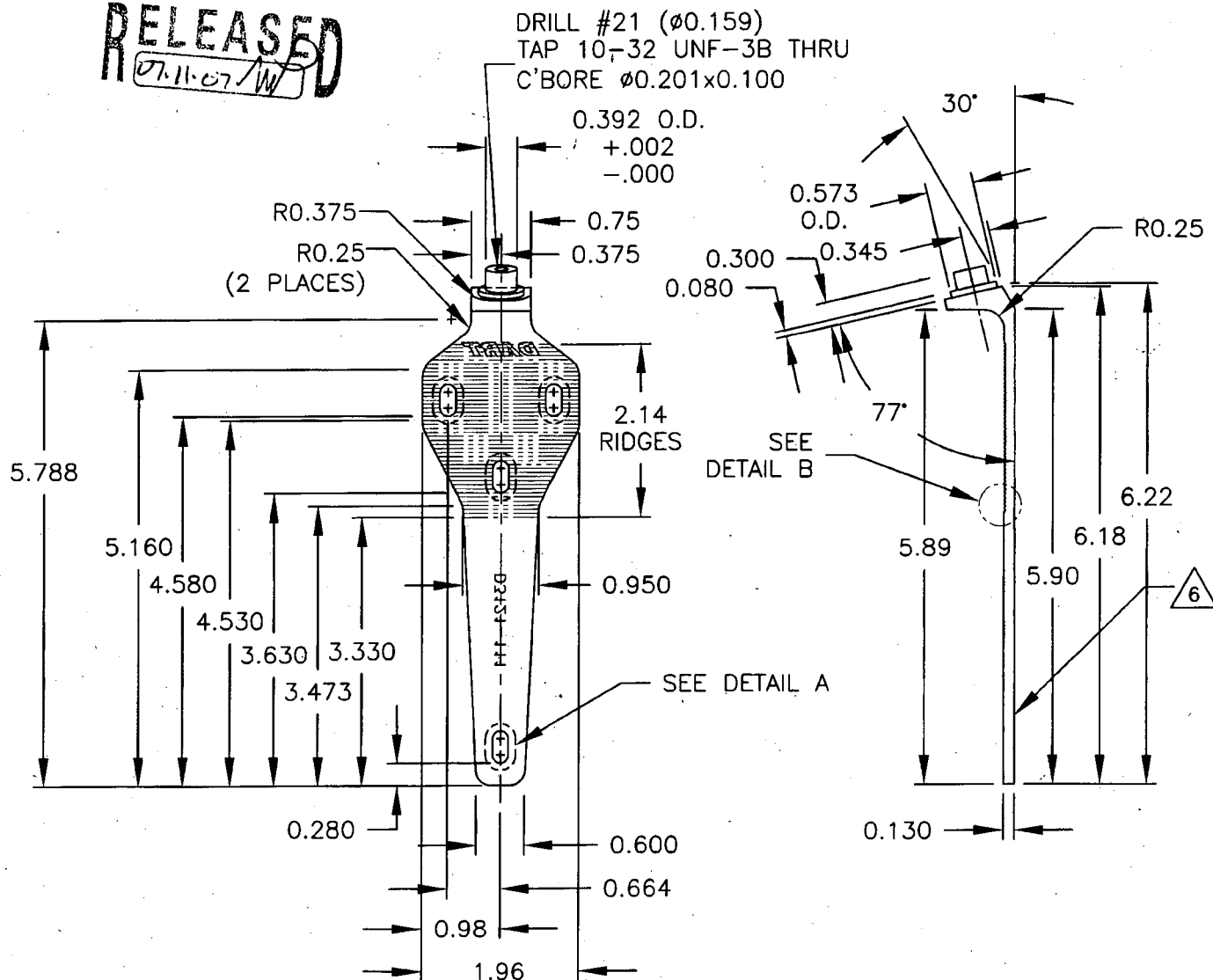
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07/W**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

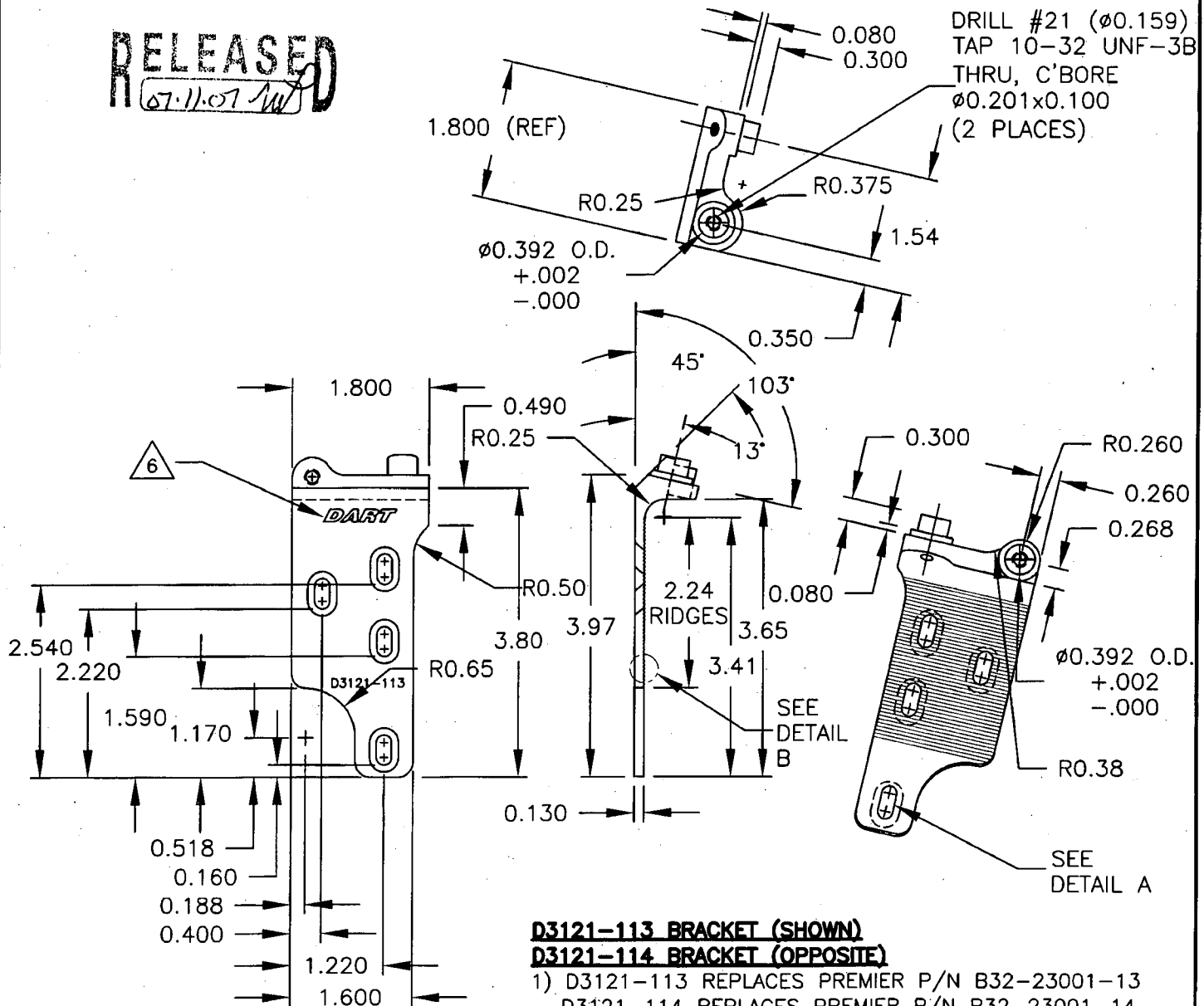
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07**D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13  
D3121-114 REPLACES PREMIER P/N B32-23001-14

- 2) MATERIAL: 17-4 SS PER AMS 5604/5643

(REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE STRENGTH = 100,000 PSI





MIN YIELD TENSILE STRENGTH = 100,000 PSI

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

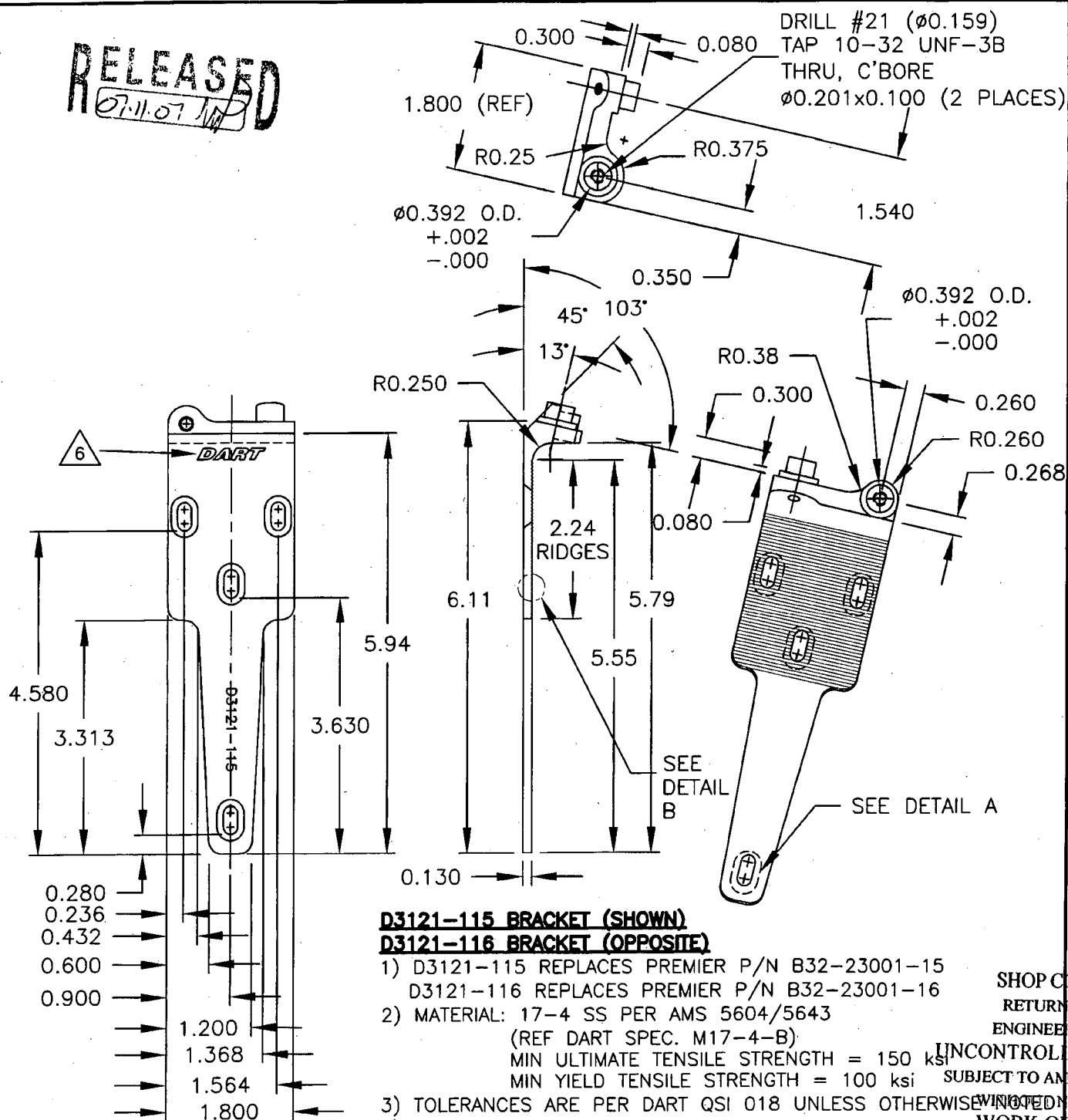
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CHECKED 	APPROVED 	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED  
07-11-07



**D3121-115 BRACKET (SHOWN)**  
**D3121-116 BRACKET (OPPOSITE)**

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15  
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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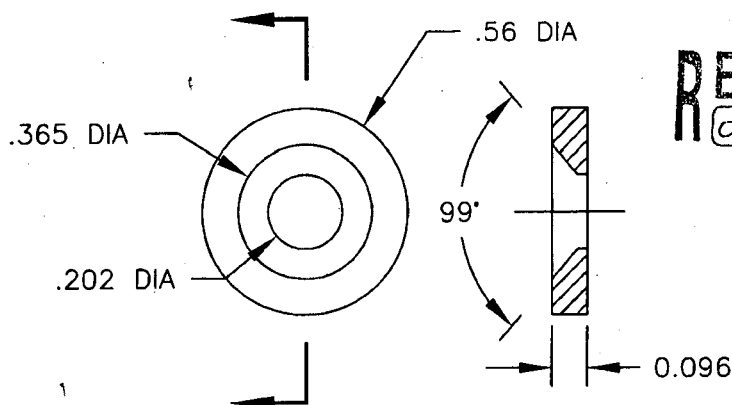
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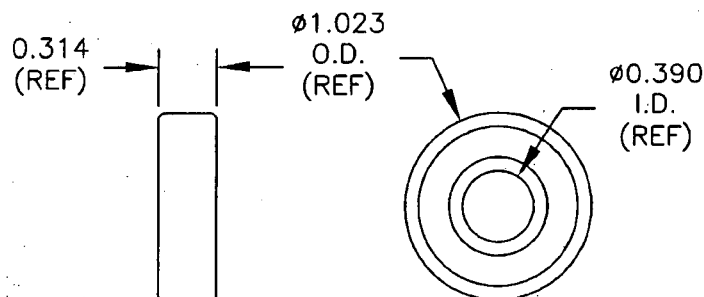
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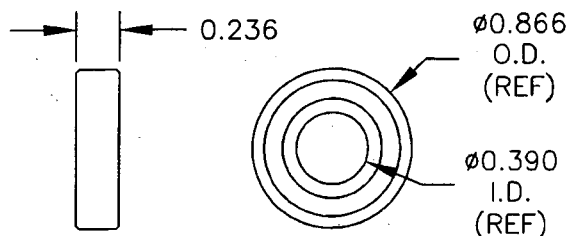
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

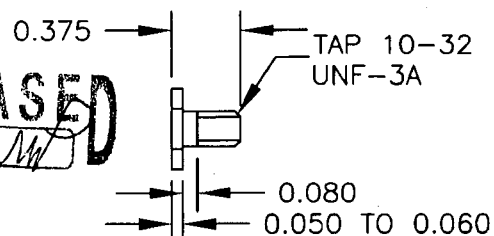
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

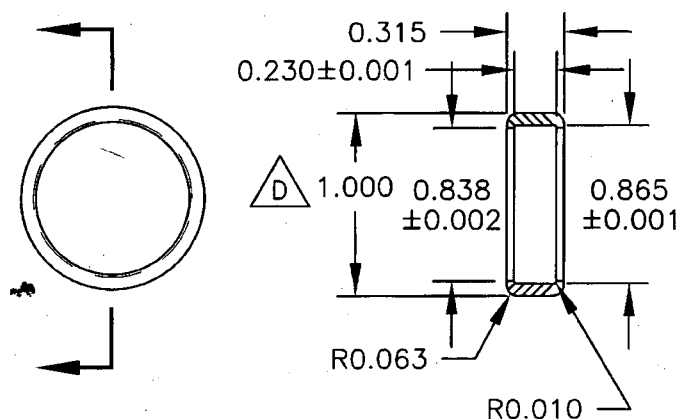
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

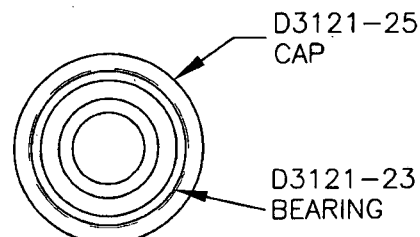
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

M. Charles

672-2839